Work Orde Wednesday, May												Page 1
Item ID: Revision ID:	D3294-5		1	Accept					Setup	Start		
Item Name:	Doubler		•	* 						Stop		
Required Date:	5/11/2011 5/16/2011	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	D:						
Reference:				· 			_	1	Run	Start		
Approvals:	Process Pla	n:	Date: //-05-/2	Tooling:	Da	ate:		J	Kuli			
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr								-	70-1	-
100				0.00							-	
Waterjet FLOW CNC Waterje		Memo 1-Cut as per Dwg Rev: Prog Rev:	Dwg D3294	0.00				Bu	<u>5-1</u>	1		(I)
		**	**grain direction as per dwg	; D3294 ****								
		2-Deburr if	necessary									
110 		QC2- Inspect parts off m	achine FAI/FAIB	0.00								
QC Quality Control		Мето	,	0.00				图11-1	5 - 17			-

W/O:);				WORK ORDER CHANGES									
DATE	STEP	PROCEDUR			IANGE	ŧ	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		·						1						
Part No	•	PAR #:	Fa	ılt Ca	tegory:	NCR:	Yes N	lo DQA	:	Date:				
	R	esolution:	Dis	posit	ion:	_ QA: N	I/C Clo	sed:		Date: _				
NCR:		\	NORK	OR	DER NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC Section A		tial Eng	Corrective Action Section Action Description Chief Eng		Sign & Date	Verifica Sectio		Approval Chief Eng	Approval QC Inspector			
				, <u> </u>		_								
							······							
					·			·						
						i e								



Page 2

Insp.

Stamp

Wednesday, May 11, 2011 4:03:50 PM D3294-5 Item ID: Accept Setup Start **Revision ID:** Stop Doubler Item Name: **Start Date:** 5/11/2011 **Start Qty: 12.00 Cust Item ID:** Required Date: 5/16/2011 Req'd Qty: 12.00 **Customer:** Reference: Run Start Process Plan: _____ Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description Run Hours Code Qty Qty Number 120 QC8- Inspect parts - second check 811201118 0.00 Memo Quality Control 130 0.00 Brake NC 0.00 SB 11/05/19 Memo Brake NC 1- Deburr if necessary

140

QC5- Inspect part completeness to step on W/O

2- Bend as per Dwg D3294

000 Duistig

Quality Control

QC

Memo

	Dart	Aeros	pace	Ltd
--	------	--------------	------	-----

W/O:				W	ORK ORDER CHANGE	ES					
DATE	STEP	PROC	CEDURE	СН	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
											<u> </u>
l											
		4									
Part No		PAR #:	_ Fault	Ca	tegory:	NCR	: Yes N	lo DQ	A:	_ Date: _	
	R	esolution:	Disp	osit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:		W	ORK	ORI	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC	Initia		Corrective Action Section Action Description	on B	Sign &	Verific		Approval	Approval
		Section A	Chief E		Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
										·	
											<u>.</u>
				i							

Work Order ID 69525

Wednesday, May 11, 2011 4:03:50 PM



Page 3

Item ID:

D3294-5

Accept



Setup Start

Stop



Revision ID:

Item Name:

Doubler

Start Date:

5/11/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 5/16/2011

QC:

Date:

SPC (Y/N):

Date:

Accept

Reject

Insp.

Work Center ID

150

Sequence ID/

HandFinish

Hand Finishing

Operation **Description**

Chemical Conversion Coat per QSI005 4.1

Run Hours

Set Up/

0.00

0.00

Code

Tool # Plan

Qty

Qty

Reject Number

Stamp

160

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

170

Packaging

Packaging

Identify as per dwg & Stock Location() A

Memo

0.00

0.00

W/O:				W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE	CHANGE By				te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Faul	t Ca	egory:	NCR: Yes	s No	DQA:	Date: _	
Resolution: Disp				osit	on:	QA: N/C	Closed	1 :	Date: _	
NCR:		V	VORK	OR	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initi Chief		Corrective Action Section Action Description	B Sigr	&	/erification Section C	Approval Chief Eng	Approval QC Inspector
			Chief	riy	Chief Eng	Dai	C			

W	ork	Or	der	ID	69525
---	-----	----	-----	----	-------

Wednesday, May 11, 2011 4:03:50 PM



Page 4

Item ID:

D3294-5

Accept



Setup Start



Revision ID:

Item Name:

Doubler

Start Date: 5/11/2011 **Required Date: 5/16/2011** **Start Qty: 12.00**

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:_____ Date:____

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop



Stop



Sequence ID/

Work Center ID

180

QC

Memo

QC21- Final Inspection - Work Order Release

Set Up/

Run Hours

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

0.00

MF 11-05-25

Dart Aerospa	ice Ltd
--------------	---------

W/O:				WORK ORDER CHA	NGES				
DATE	STEP	PRO	CEDURE	CHANGE	В	у	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault	Category:	NCR: `	Yes No	DQA:	_ Date: _	
	R	esolution:	Dispo	sition:	QA: N/	C Clos	ed:	Date: _	
NCR:		V	VORK C	RDER NON-CONFOR	RMANCE (I	NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descripti	Section B	ign &	Verification	Approval	Approval
		Section A	Chief En	ng Chief Eng		Date	Section C	Chief Eng	QC Inspector

Picklist Print

Wednesday, May 11, 2011 4:03:56 PM

Work Order ID: 69525

Parent Item:

D3294-5

Parent Item Name: Doubler



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No	,		100	sf	115.5000	0.065	0.821053	1.5	•	
2024 T2 . 080 short										6	311-5-1	1	

2024-T3 .080 sheet

Loc Qty	Loc Code	
115.5		
6		
4		(20)
2		110347
3		
3		
7		
17.2		·
7.8		
65.5		
	115.5 6 4 2 3 3 7 17.2 7.8	115.5 6 4 2 3 3 7 17.2 7.8

W/O:			-	WORK ORDER CH	IANGES				
DATE	STEP	PRO	CEDURE	CHANGE	Ву	, [Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							;		
Part No		PAR #:	_ Fault	Category:	NCR: Y	es No	DQA:	Date: _	
	R	esolution:	Disp	sition:	QA: N/0	C Clos	ed:	Date: _	-
NCR:		V	ORK (ORDER NON-CONFO	ORMANCE (N	ICR)			
DATE	STEP	Description of NC Section A	Initia			gn &	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Chief Er	ng Chief Eng		ate			
								1	

DART AEROSPACE LTD	Work Order:	69525
Description: Doubler	Part Number:	D3294-5
Inspection Dwg: D3294 Rev: C		Page 1 of 1.

FIRST ARTICLE INSPECTION CHECKLIST

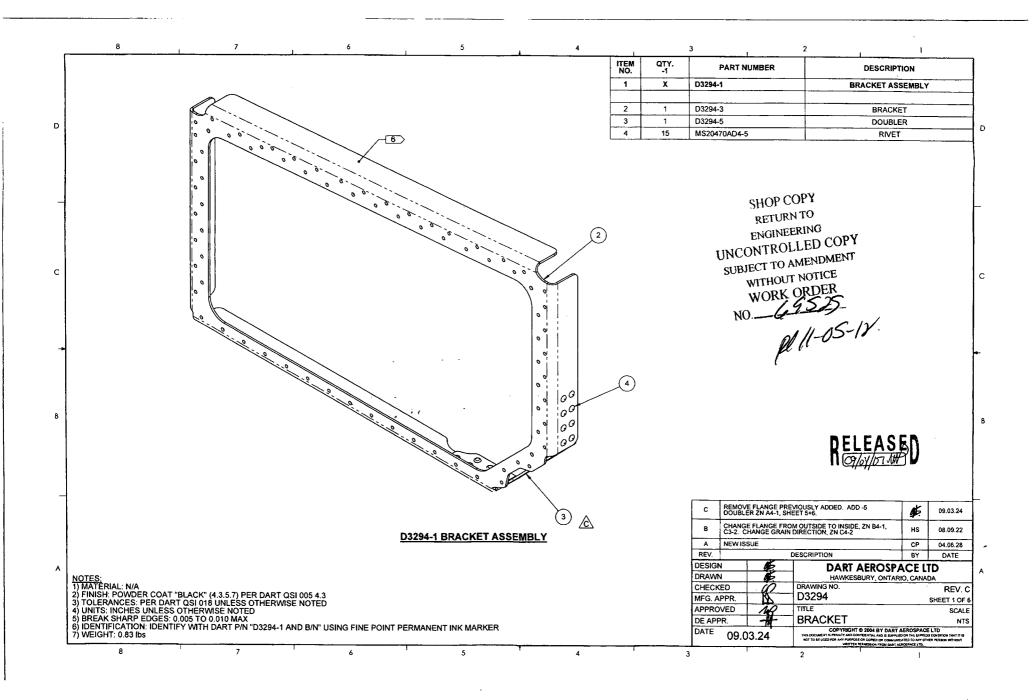
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	,131	8		V 1807	
0.65	+/-0.030	,652	4		V	
0.30	+/-0.030	303	y		V	
0.53	+/-0.030	,53	×		ν	
3.36	+/-0.030	3,366	7		ν	
2.50	+/-0.030	2.50(7		V	
0.15	+/-0.030	.151	8		V	t
9.21	+/-0.030	9,716			PROWZOZ	
0.400	+/-0.010	399	8		V	
0.300	+/-0.010	(3c3	1		V	
0.30	+/-0.030	- 300	6		b	
0.625	+/-0.010	.624	>		V	
0.080	+/-0.010	580,	A		V	
1.00	+/-0.030	1.008	>		ν	
						·
						<u>.</u> .

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-5-17	Date: 11/1/18	Date:	N/A

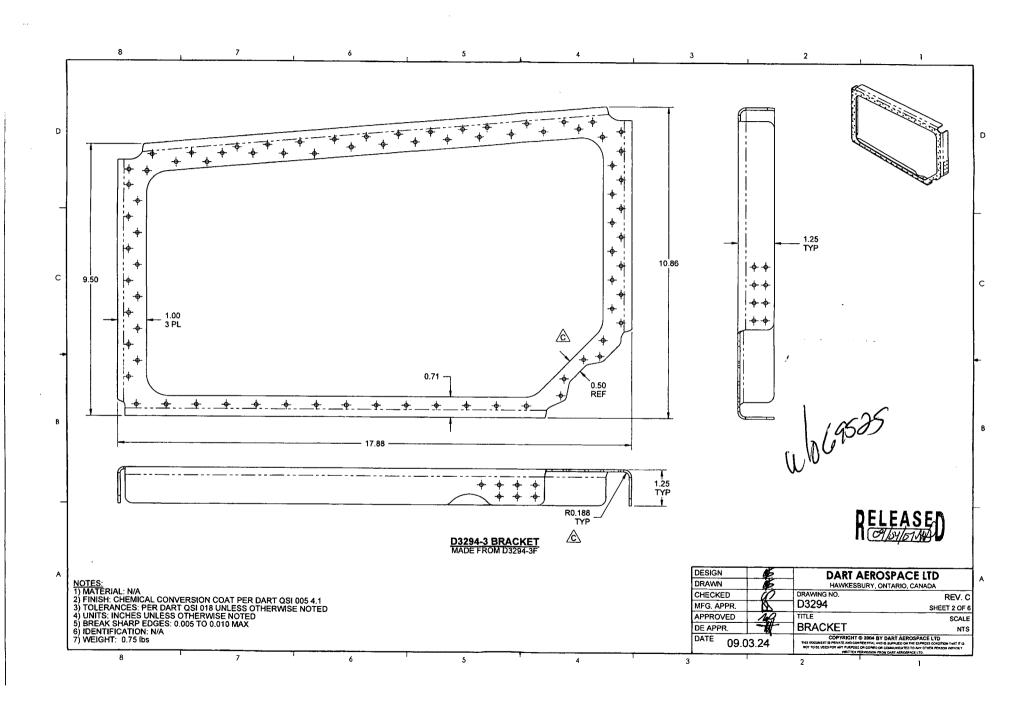
Rev	Date	Change	Rev	ise	l by	Appro	ved
Α	09.07.29	New Issue	KJ	94	<u>}</u>		_
					,	100	

W/O:			W	ORK ORDER CH	IANGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		~								
		<i>*</i>								
Part No	•	PAR #:	Fault Cate	egory:	N	CR: Yes	No DQ	A:	Date:	
Resolution:			Disposition	QA: N/C Closed: Da				Date: _		
NCR:		,	WORK ORE	ER NON-CONF	PRMANO	E (NCF	?)	·		
DATE	CTED	Description of NC	f NC Corrective Action			Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri	ption	Sign 8 Date		cation on C	Chief Eng	QC Inspector
· · · ·										:
			ļ.				į			
	1			1			Į.			1



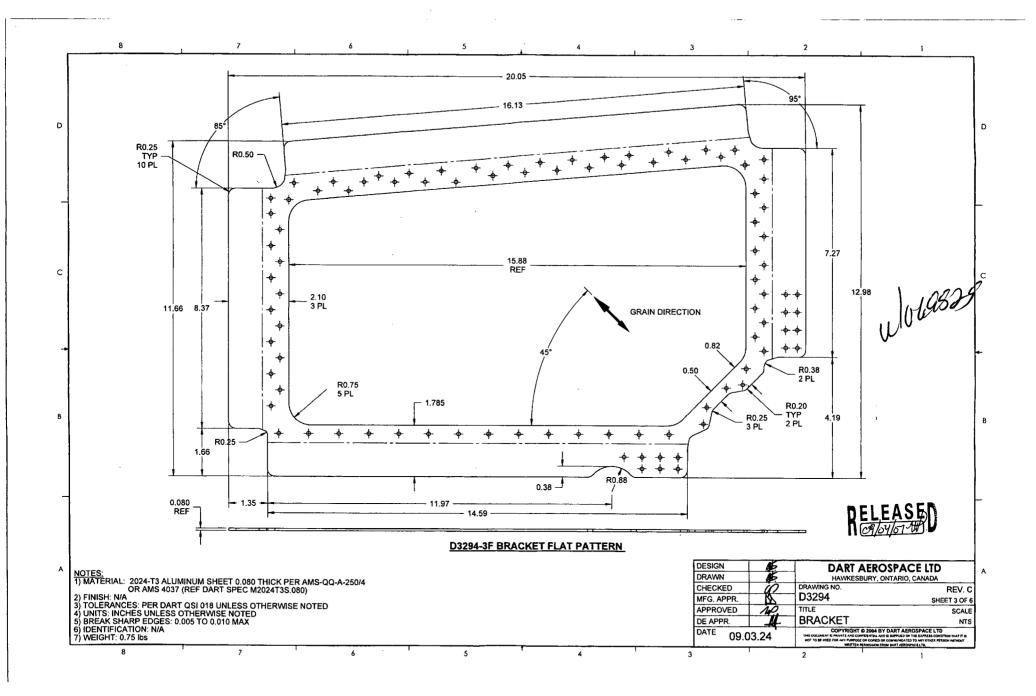
Dart Aerospa	ce Ltd
--------------	--------

Dart Ae	rospace	e Ltd								•
W/O:				WORK ORDER	CHANGES					
DATE	STEP	PRO	OCEDURE	CHANGE	-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								
Part No	:	PAR #:	Fault	Category:	NC	R: Yes	No DQ	A:	Date:	
	Resolution: Dispo		sition:	QA	: N/C Clo	sed:				
NCR:		•	WORK (RDER NON-CON	IFORMANCI	E (NCR)			
DATE	STEP	Description of NC Section A	Initia	Corrective Action Des		Sign &	Verific Secti	eation	Approval Chief Eng	Approval QC Inspector
		Coolion	Chief E	ng Chief E	ing	Date	00011	011 0	Onio, Eng	QO MOPOSIOI
								·		

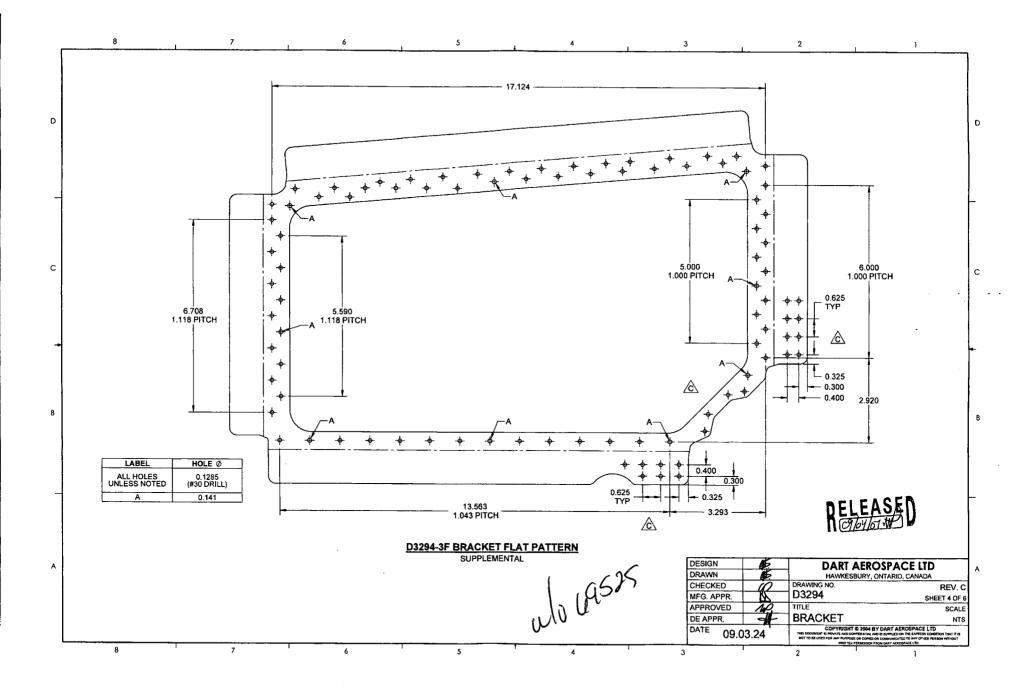


Dart	Aeros	pace	Ltd
------	-------	------	-----

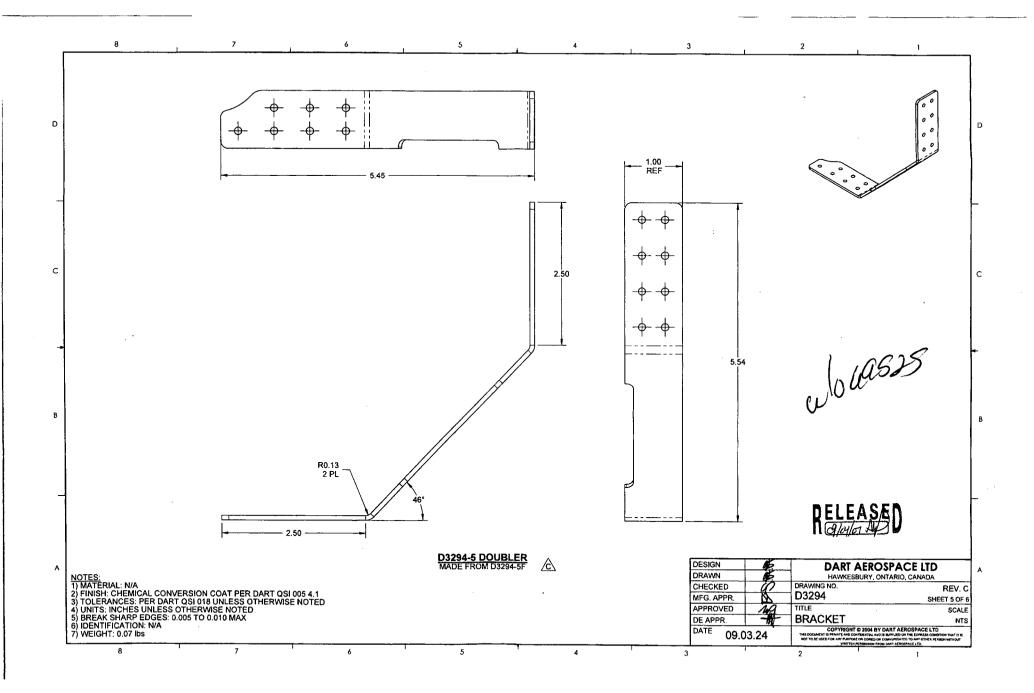
W/O:				WORK ORDER C	HANGES				
DATE	STEP	PRO	CEDURE	CHANGE	В	у С	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
······································									
Part No	:	PAR #:	Fault	Category:	NCR: Y	es No	DQA:	Date: _	
Resolution:		1							
NCR:		V	VORK ¢	RDER NON-CONI	ORMANCE (N	ICR)			
DATE	STEP	Description of NC Section A	Initia Chief Er	Corrective Action Action Desc	ription Si	gn & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Officer da	ig Office Elli		Jace			
				,					
									!
	1			1	·	- 1		İ	1



W/O:			ļ	WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE	CHANGE		Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	Part No: PAR #:		1								
Resolution:		Dispos	sition:	QA:	N/C Clo	sed:	Date: _				
NCR:			WORK O	RDER NON-CON	FORMANCE	(NCR)					
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Desc		Sign &	Verification Section C		Approval QC Inspector		
		Section A	Chief Eng			Date	Section C	Office Eng	QO Mapector		
	ļ										
	1	I		i i			1	ı	i		

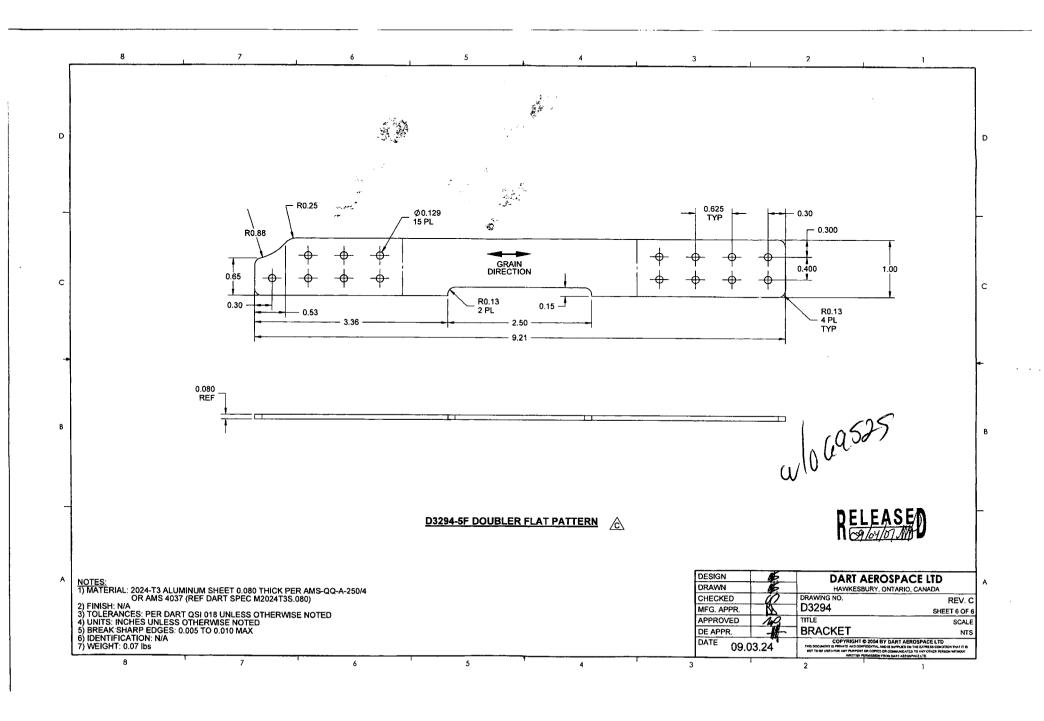


W/O:				WORK ORDER CI	HANGES				
DATE	STEP PROCEDURE		CHANGE		Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							:		
Part No	:	PAR #:	_ Fault	Category:	NCR: Ye	es No	DQA:	_ Date: _	
Resolution:					-				
NCR:		W	ORK (RDER NON-CONF	ORMANCE (N	CR)			
DATE	STEP	Description of NC	Initia	Corrective Action Action Descr	Section B	n &	Verification	Approval	Approval
		Section A	Chief Er			ate	Section C	Chief Eng	QC Inspector
								•	
3.4.									
								,	
!			1 1	}					



Dart	Aeros	pace	Ltd
------	--------------	------	-----

W/O:				WORK ORDER C	HANGES				
DATE	STEP	PRO	CHANGE		Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			· · · · · · · · · · · · · · · · · · ·						
Part No:	PAR #:	Fault	Category:	NCI	R: Yes N	lo DQA: _	Date: _		
	R	esolution:	Dispo	sition:	QA	QA: N/C Closed:			
NCR:			WORK (RDER NON-CON	FORMANCE	(NCR)			
DATE	STEP	Description of NC Section A		Corrective Action Initial Action Descrip		Section B Vention Sign &			Approval QC Inspector
			Chief E	ng Chief En	9	Date			



W/O:			WORK ORDER CHANGES						
DATE	STEP	PROCEDURE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			Date of C	10					
		`	Q Ta		* A			or e ,	
Part No	o:	PAR #: Fault	Category:	NCR:	Yes	No DQ	A:	Date: _	

				-				
Resolution: Dispo			Disposition):	QA:,N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFO	RMANCE (NCR)			
		Description of NC Section A		Corrective Action Section B			Ammuoval	Annroyal
DATE	STEP		Initial Chief Eng	Action Descrip	otion Sign & Date	- Verification Section C	Approval Chief Eng	Approval QC Inspector
								ļ
:						·		